

Date: Monday, 7/9/2007 3:44:09 PM
 User: Kim Johnston

Process Sheet

MAT'L N 24/07

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RING
Job Number : 33433	
Estimate Number : 10795	
P.O. Number :	Part Number : D34131
This Issue : 7/9/2007 S.O. No. :	Drawing Number : D3413 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 32408	Material :
Written By :	Due Date : 7/20/2007 Qty: 15 Um: Each
Checked & Approved By : <u>7/9/07.07.10</u>	
Comment : Est Rev:A 05.09.13 New issue KJ/JLM	
Est Rev:B Now on Waterjet 07-05-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3413

Dwg Rev: BProg Rev: B

2-Deburr if necessary

SAD

07/08/13

(15)

2.0	M304B0250X4000	304 BAR .250 x 4.00
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Comment: Qty.: 0.2625 f(s)/Unit Total : 5.2500 f(s)

304 BAR .250 x 4.00

Batch: M107640

SAD

07/08/13

(15)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07/08/13

(15)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/08/13

counted
(15)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1.

SAD 07/08/13

(15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 3:44:09 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 33433

Part Number: D34131

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/13 (15x) (coated)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105 068

BR/M-P 07-08-14

(15x)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/8/15 SQ (15x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/08/15 (15x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-08-15

Job Completion



U 07-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

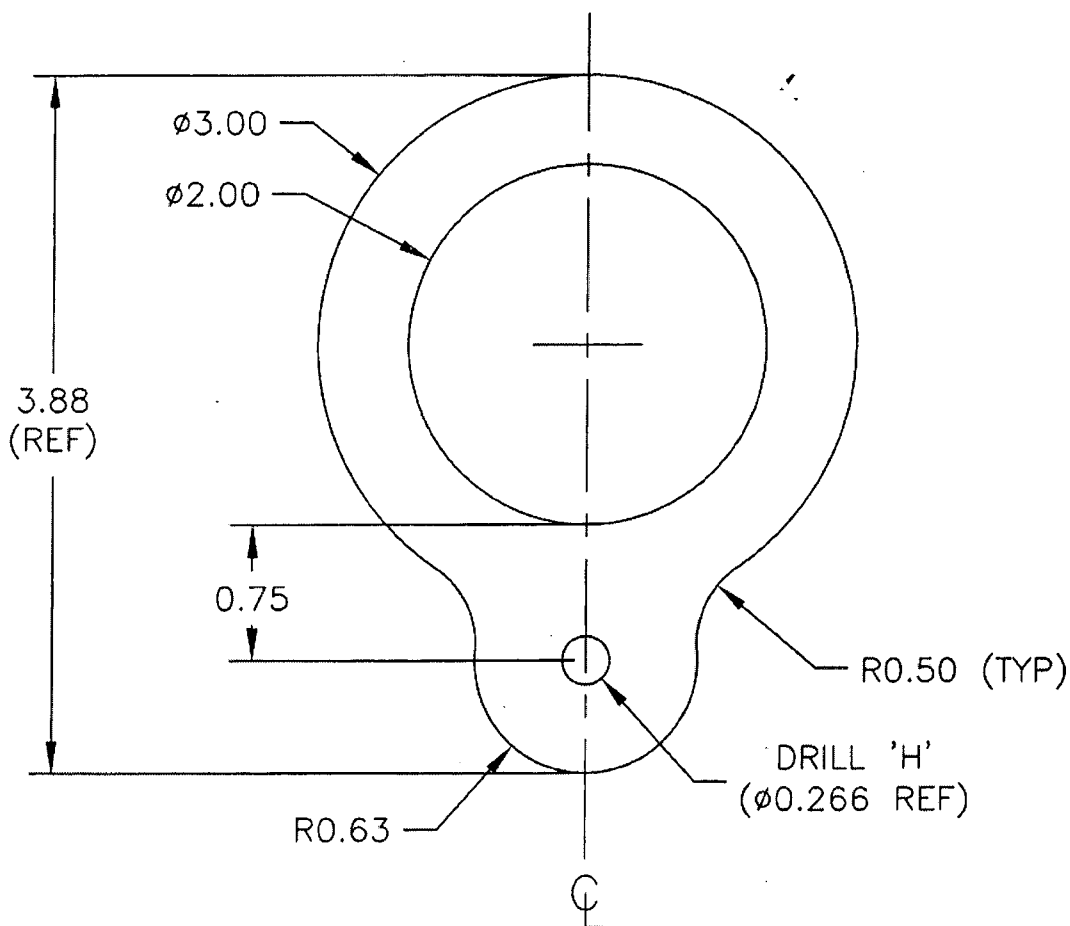
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06



D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304/316)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
DART AEROSPACE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33433

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DART AEROSPACE LTD		Work Order:	33433
Description: Ring		Part Number:	D34131
Inspection Dwg: D3413 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by: SAD	Audited by: EP	Prototype Approval: N/A
Date: 07/08/13	Date: 07/08/13	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	